

Work Order ID 52225

Monday, September 21, 2009 11:41:09 AM



Page 1

Item ID: D3315-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

9-9-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3315 | Rev B | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 99-25

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 99-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 S 02/02/25

(X2)

Work Order ID 52225

Monday, September 21, 2009 11:41:09 AM

Page 2

Item ID: D3315-1

Accept

Setup Start

Revision ID: B

Stop

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

N/A

140



Brake NC

Brake NC

NC BRAKE

Memo

1- Form using DT8751 Die as per Dwg D3315Rev: B □ 2- Form using
DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: B

0.00

0.00

802/10/01

8 2

150



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

802/10/01

①
XS P

Work Order ID 52225

Monday, September 21, 2009 11:41:09 AM



Page 3

Item ID: D3315-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160



Large Fab

Large Fab

0.00

Memo

0.00

Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:

☐ Qty Part Number Description Batch ☐ A/RN/A 7560 Hardcoat Rod M109060EL 9-10-6 (X7)

170



QC

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) 8 07/10/06(X7) f

Quality Control

180



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 07/10/06(X7) f

Quality Control

| W/O: 52225 | | WORK ORDER CHANGES | | | | | |
|------------|------|---|---------------|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09/10/05 | | take take 1 to make new template | EL 9-10-06 | 09/10/05 | | L | |
| | | | | | | | |

Part No: D3315-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 52225

Monday, September 21, 2009 11:41:09 AM

Page 4

Item ID: D3315-1

Revision ID: B

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 8.00

Required Date: 10/2/2009 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M109091

Memo

0.00

Powder Coating

START TIME: 1:15

OVEN TEMPERATURE:

200° FINISH TIME: 1:45

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9/10/17 7k SP

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3315-1, B/N: BXXXXX ☐For Product Eligibility see PDA04-17 ☐and Stock ☐Location: _____

9/10/17 7k SP

Work Order ID 52225

Page 5

Monday, September 21, 2009 11:41:09 AM

Item ID: D3315-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08

U 09.10.08

Picklist Print

Page 1

Monday, September 21, 2009 11:41:09 AM

Work Order ID: 52225



Parent Item: D3315-1RevB



Parent Item Name: Wearplate

Start Date: 9/21/2009

Required Date: 10/2/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M1010S16GA

Purchased

No

100

sf

111.6200

14.1250



13 9-9-25

1010/1025 sheet 16GA

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.62

105706

0.6

111410

111.02

105706

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: S2225 |
| Description: WEARPLATE | | Part Number: D3315-1 |
| Inspection Dwg: D3315-1 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

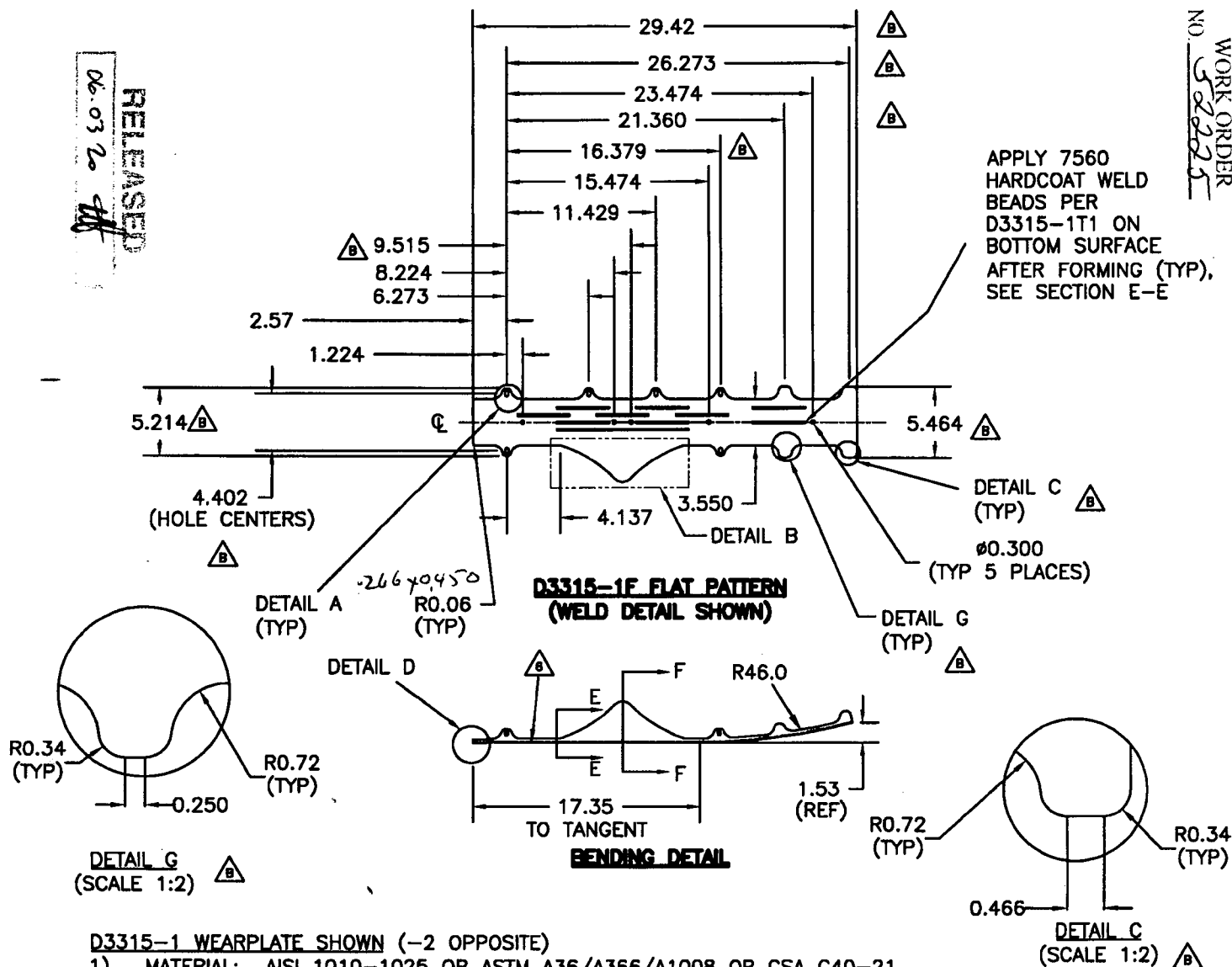
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .266X.450 | + .006 - .001 | .268X.453 | * | | | |
| 4.403 | ± .010 | 4.403 | * | | | |
| 4.137 | ± .010 | 4.138 | * | | | |
| 3.553 | ± .002 | 3.554 | * | | | |
| 5.464 | ± .010 | 5.462 | * | | | |
| 5.214 | ± .010 | 5.210 | * | | | |
| 1.224 | ± .010 | 1.226 | * | | | |
| 2.57 | ± .030 | 2.565 | * | | | |
| 6.273 | ± .010 | 6.274 | * | | | |
| 8.224 | ± .010 | 8.226 | * | | | |
| 9.515 | ± .010 | 9.513 | * | | | |
| 11.429 | ± .010 | 11.429 | * | | | |
| 15.474 | ± .010 | 15.474 | * | | | |
| 16.379 | ± .010 | 16.379 | * | | | |
| 21.360 | ± .010 | 21.360 | * | | | |
| 23.474 | ± .010 | 23.474 | * | | | |
| 26.273 | ± .010 | 26.273 | * | | | |
| 29.42 | ± .030 | 29.42 | * | | | |
| .060 | ± .010 | .056 | * | | | |
| Ø .300 | + .006 - .001 | .302 | * | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|------------------------|-----------------------|----------------------------|-----|
| Measured by: JB | Audited by: S | Prototype Approval: | N/A |
| Date: 9-9-25 | Date: 09/09/25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

DARTSHIP COPY
RETURN TOUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52225

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|--------------------|--------------------|-----------------------------|
| 04 | 04 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| <i>[Signature]</i> | <i>[Signature]</i> | D3315 |
| DATE | TITLE | REV. B |
| 06.01.31 | WEARPLATE | SHEET 1 OF 4 |
| A | 04.09.10 | SCALE |
| B | 06.01.31 | 1:12 |
| UPDATE DIMENSIONS | | |

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

RELEASED

06.03.20

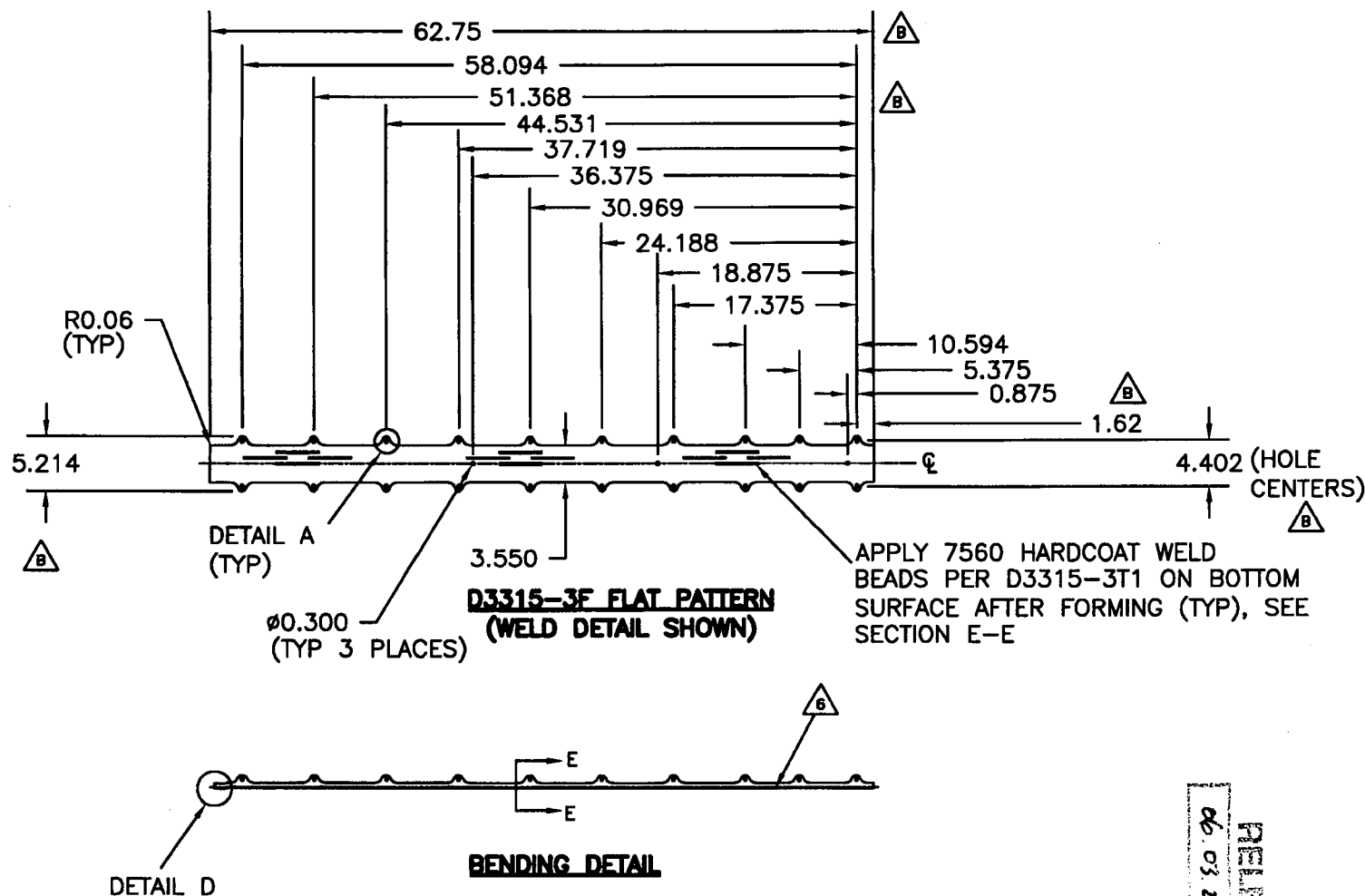
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

W/6 52225

| | | | | |
|---------|--------------------|-------------|--------------------|-----------------------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.01.31 | DRAWING NO. | D3315 | REV. B |
| | | TITLE | WEARPLATE | SHEET 2 OF 4 |
| | | | | SCALE 1:16 |

RELEASED
06.03.20 *[Signature]***D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

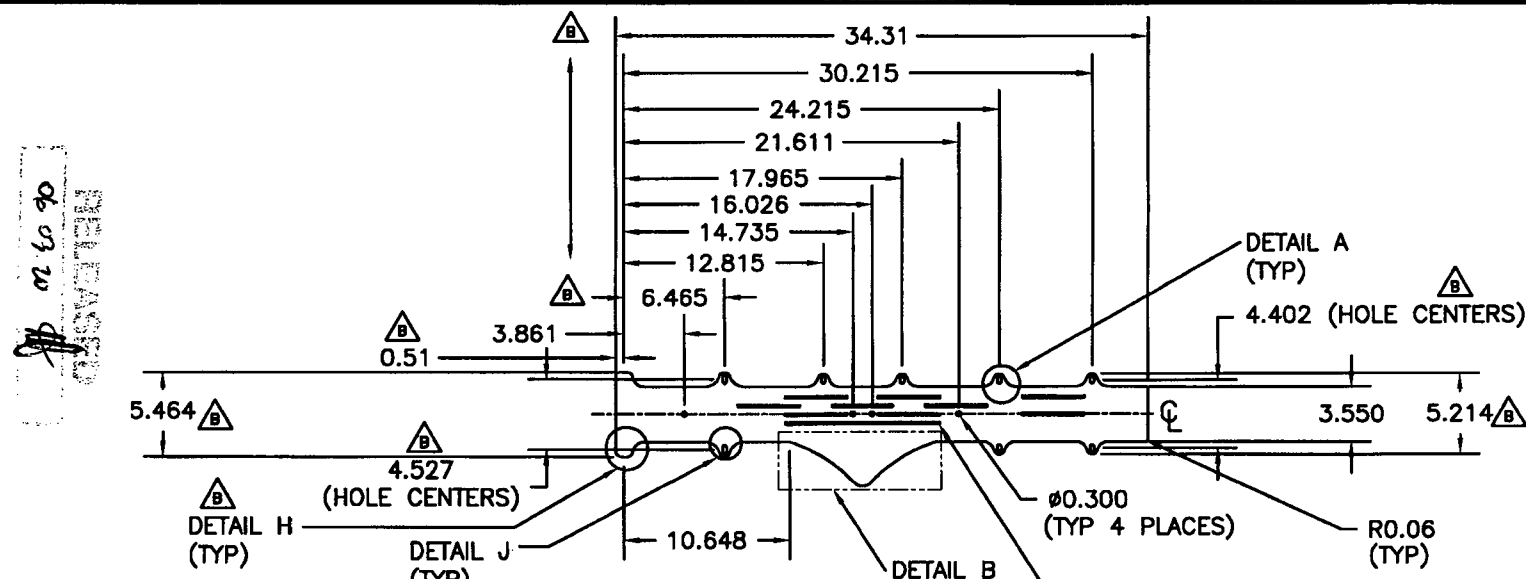
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

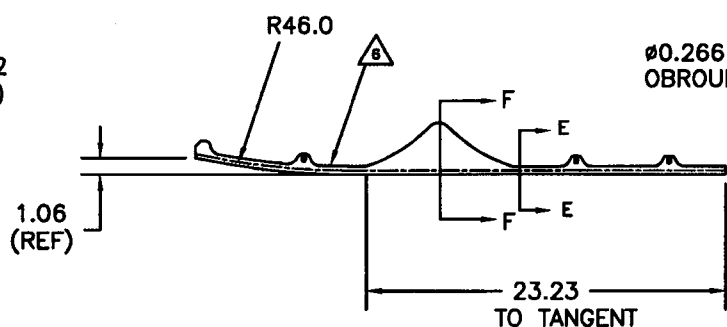
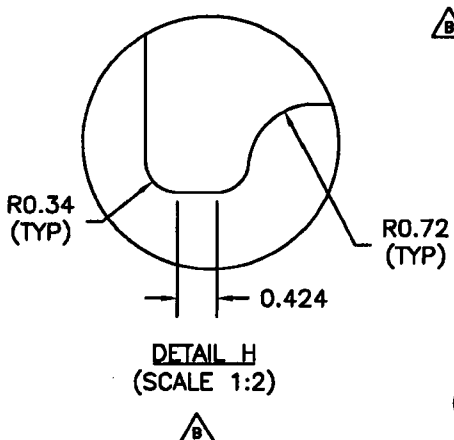
W/B 52225

| | | | | |
|---------|-----------|--------------|-------|-----------------------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.01.31 | DRAWING NO. | D3315 | REV. B |
| TITLE | WEARPLATE | SHEET 3 OF 4 | | |
| SCALE | 1:12 | | | |

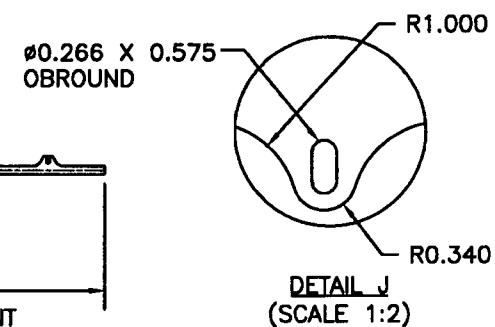


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

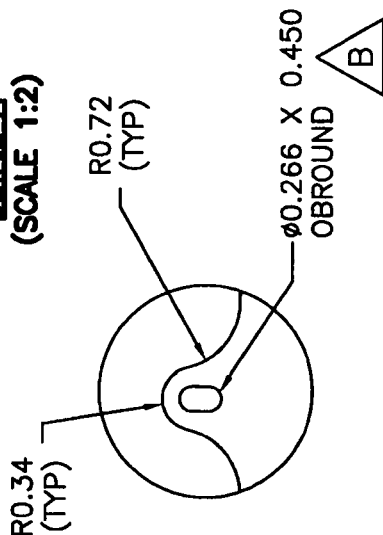
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

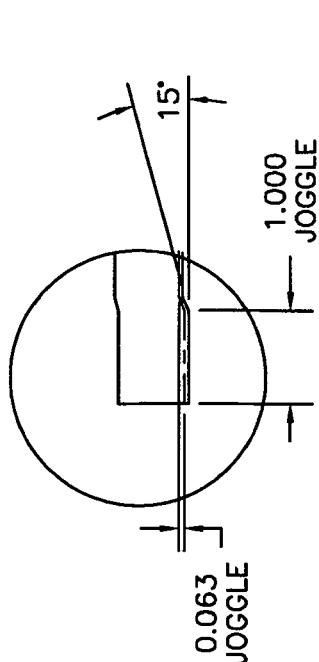
W/O 52225

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3315 | REV. B SHEET 4 OF 4 |
| DATE 06.01.31 | TITLE WEARPLATE | | SCALE NTS |

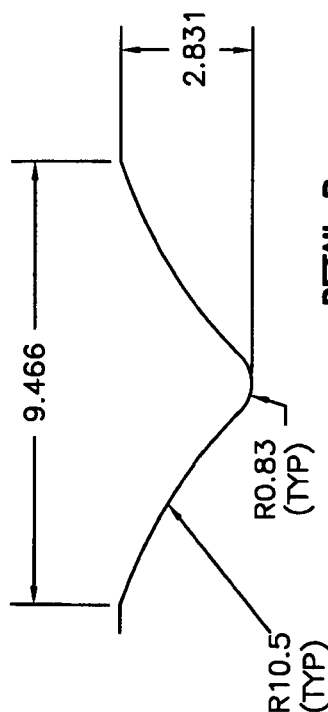
DETAIL A
(SCALE 1:2)



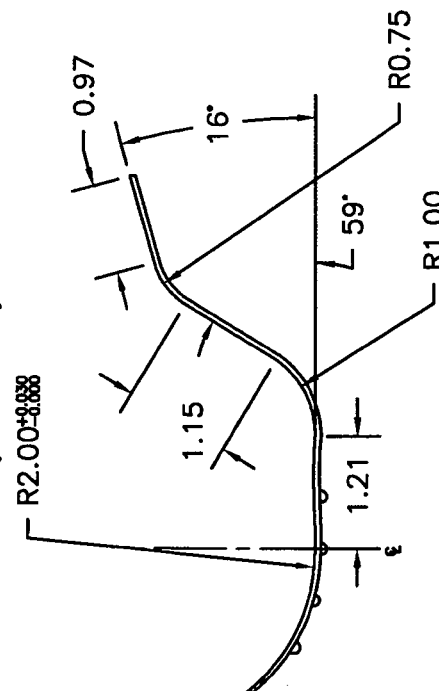
DETAIL D
(SCALE 1:2)



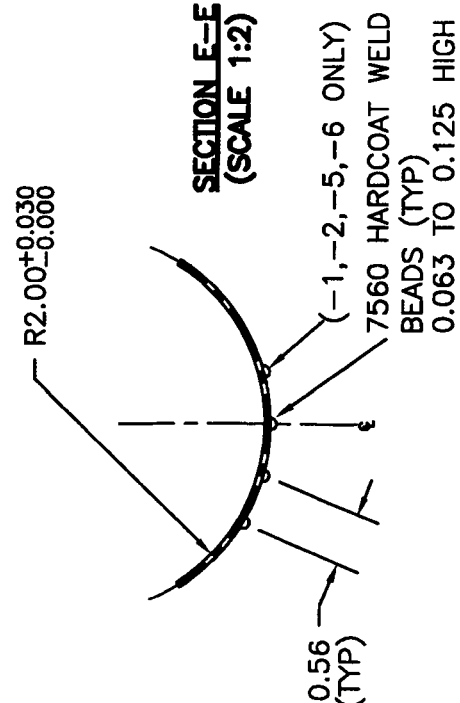
DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)



RELEASED
06.03.20 [Signature]

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.